

5/42

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	24400
<b>Description:</b> Bushing	<b>Part Number:</b>	D2617-3
<b>Dwg:</b> D2617 Rev. DT D2 05.10.03 05.10.03	<b>Qty:</b>	50 51
		Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler	PK	05.10.04	50
2	MC	Machine as per Folio FA437 and Dwg D2617 Material: 6061-T6 (QQ-A-225/8 or QQ-A-200/8 or WW-T-700/6) Ø0.375" tubing x 0.058" wall (M6061T6T0.375W.058) Identify as D2617-3 Batch: <u>M18730</u>	Fin	05/10/26	51
3	QC2	Inspect parts as they come off the CNC machine	Fin	05/10/26	51
4	QC8	Second check	J.L	05/10/26	51
5	GA	Deburr break all unmarked sharp edges 0.005 to 0.010	DL	05/10/31	51
6	FP	Acid Etch and Alodine as per QSI 005 4.1	SND	05/11/19	59
7	QC5	Inspect work to Step 3	C.L	05/11/24	51
8	ST	Identify and Stock Loc: 49	/	05/11/24	51
9	AC	Cost / part:	SAC	05-11-25	51
10	DC	Close W/O Inspect Level 21	PK	05/11/25	51

Rev	Date	Change	Revised By	Approved
D	98.04.16	Re-Format	KB	
E	99.08.23	Re-format, added notes and inspection level	EC	
F	01.01.03	Re-format, made in-house	EC	
G	04.07.14	Reformat; added step 5	KJ/JLM	

RELEASED

10/07.14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA:  Date: 03/11/25

NOTE: Date & initial all entries

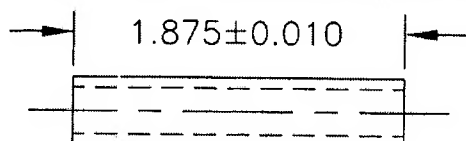
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_



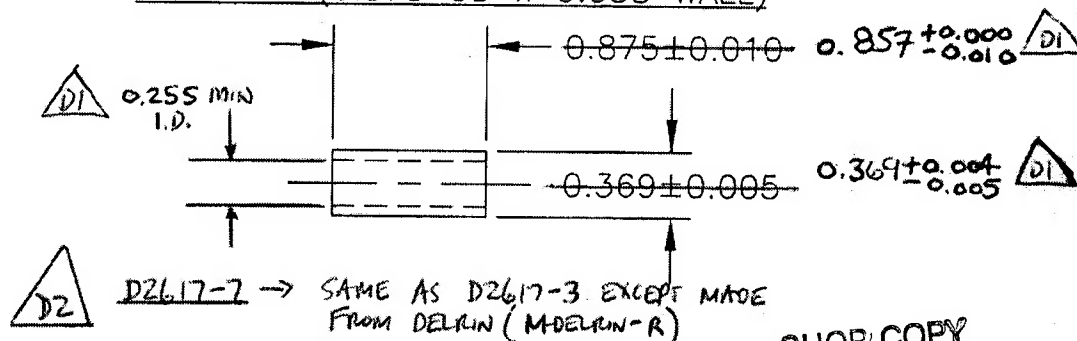


DESIGN	BW	DRAWN BY	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	#	APPROVED	#	DRAWING NO. D2617	REV. D SHEET 1 OF 1
DATE	01.07.04			TITLE BUSHING	SCALE 1:1
D2	04.09.10	CP	ADD D2617-7	A	96.10.08 NEW ISSUE
				B	97.05.08 .875 WAS 1.125
				C	97.06.04 0.369 DIA WAS 0.375
				D	01.07.04 ADD MAT'L SPEC AND TOL./DIM. NOTE
				DI	CP 04.07.12 CORRECT TOLERANCE (NCR 779)

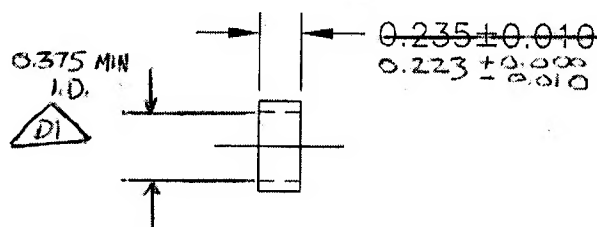
D2617-1 (0.375 OD x 0.058 WALL)



D2617-3 (0.375 OD x 0.058 WALL)



D2617-5 (0.500 OD x 0.058 WALL)



RELEASED  
01.07.05

SHOP COPY  
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ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 24400

NOTES:

- 1) MATERIAL: 5052-H32 (QQ-A-225/7 OR WW-T-700/4)  
OR 6061-T6 (QQ-A-225/8, QQ-A-200/8, OR WW-T-700/6)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) FINISH: ACID ETCH, ALODINE PER QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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# Job Costing Report

Dart Aerospace Ltd.  
Hawkesbury

Oct 03, 2005  
11:23 am

Work Order No : 0024400  
Project Name : D2617-3  
Project For : WK542  
Work Order Type : Main  
Main WO Number :  
House Part Number : D2617-3  
Description : Bushing  
Manufactured : Yes  
Amount Req'd : 50  
Amount Done : 0  
Start Date : 10-03-05  
Est Finish Date : 10-20-05  
Act Finish Date :  
Drawings Req'd : No  
Ok for Approval :  
Approval Rec'd :

Department Code:  
Burden Flags : NNNNNNNN  
WO Status : Open  
Invoice State : Not Invoiced  
Invoice Date :  
Invoice Number :  
Invoice Amount : 0.00  
Order Entry No :  
OE Value : 0.00  
Est Mark Up : 0.000%  
Actual Mark Up : 0.000%  
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00